

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025226**Date Inspected:** 13-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Shi Yu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

**Blasting Bay # 4**

This QA inspector performed after blasting inspection on top deck plate of OBG 13 AW, BW, at blasting bay 4, QA inspector find out eight(8) locations of deep arc gouge marks to be weld repair areas and three(3) locations are need grind smooth of temporary support removed area.

Locations:

**13AW**

1, Need weld repair at PP118 to between longitudinal weld seam No 001 and longitudinal weld seam No 002

2, Need weld repair at PP118 to between longitudinal weld seam No 002 and longitudinal weld seam No 004

3, Need weld repair at PP120 to between longitudinal weld seam No 004 and longitudinal weld seam No 005

4, Need weld repair at PP119 to between longitudinal weld seam No00 4 and longitudinal weld seam No 005

5, Need grind at PP117.5 to between longitudinal weld seam No 004 and longitudinal weld seam No 005

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6, Need weld repair at PP118.5 to between longitudinal weld seam No 007 and longitudinal weld seam No 008

7, Need grind at PP120 to between longitudinal weld seam No 010 and longitudinal weld seam No 011

13BW

1, Need weld repair at PP121.5 to between longitudinal weld seam No 001 and longitudinal weld seam No 002

2, Need weld repair at PP121.5 to between longitudinal weld seam No 004 and longitudinal weld seam No 005

3, Need weld repair at PP121.5 to between longitudinal weld seam No 007 and longitudinal weld seam No 008

4, Need grind at PP121.5 to between longitudinal weld seam No 009 and longitudinal weld seam No W15

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Fing.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Splice angle

PCMK: X-3860A

Welder: 203871

WPS-B-T-2231-ESAB

This QA Inspector observed the following work in progress for Bay 14

ZPMC performed grind work and drilling on U-Rib splice channel.

Bay 16

This QA Inspector observed the following work in progress for Bay 16

ZPMC performed SMAW tack welding on hand rail and VT repair welding on Steel Barrier.

Also grind work, pre assembly work on steel barrier.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as follows; OBG 13E &W, on item number 1~25 of NWIT tracker document # 09459,

Bay 19

This QA Inspector observed the following work in progress for Bay 19

ZPMC performed SMAW VT repair welding and grind work on BK 25A.

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an

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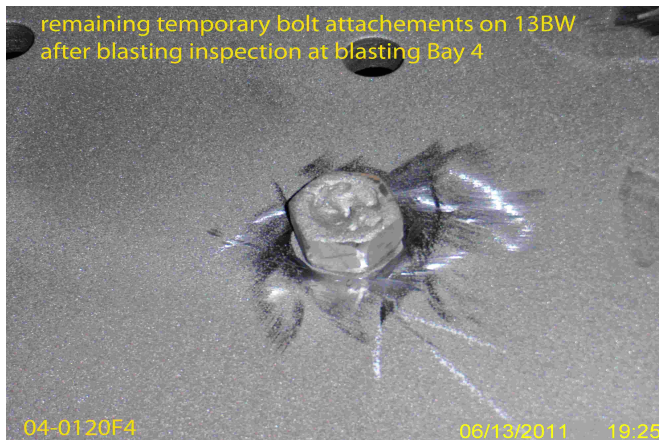
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MT report for this date. The member(s) is/are identified as follows; BK025A-001-and BK24A-001 on item number 1& 2 of NWIT tracker document # 09460,

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Shin,DJ   | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Riley,Ken | QA Reviewer                 |

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